

Used in 37300

Dart Aerospace Ltd.

Date: Monday, 11/12/2007 10:51:37 AM
 User: Chantal Lavoie

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: STEP EXTRUSION	
Job Number	: 35618		Part Number	: D2622120C	
Estimate Number	: 10058		Drawing Number	: D2622 REV C1	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 11/12/2007 S.O. No. : N/A		Drawing Revision	: C1	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 11/30/2007	
Previous Run	: 34694		Qty:	110 Um: Each	
Written By	: <u> </u>				
Checked & Approved By	: <u> </u>				
Comment	: Est. A: <u> </u>		New Issue	KJ/RF	

Additional Product

Job Number:

Description :

PURCHASING



Ct

1013

C207110112

(132) 121

as per Dwg D2622 Rev. C
 Material: 6061-T6 (QQ-A-200/8)
 c) Minimum yield tensile strength = 35 ksi
 d) Minimum ultimate tensile strength = 38 ksi
 e) Minimum elongation = 8%
 f) Order at 120" longg) Bon L Canada Inc. tool # 897123 Rev. A
 h) To be packed per DSK 066
 i) Pull test to ASTM standard B221 required.
 j) Material certification is required

2.0 D2622120CP Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 110.0000 Each(s)

Extrusion

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage
 Ensure material certification is attached

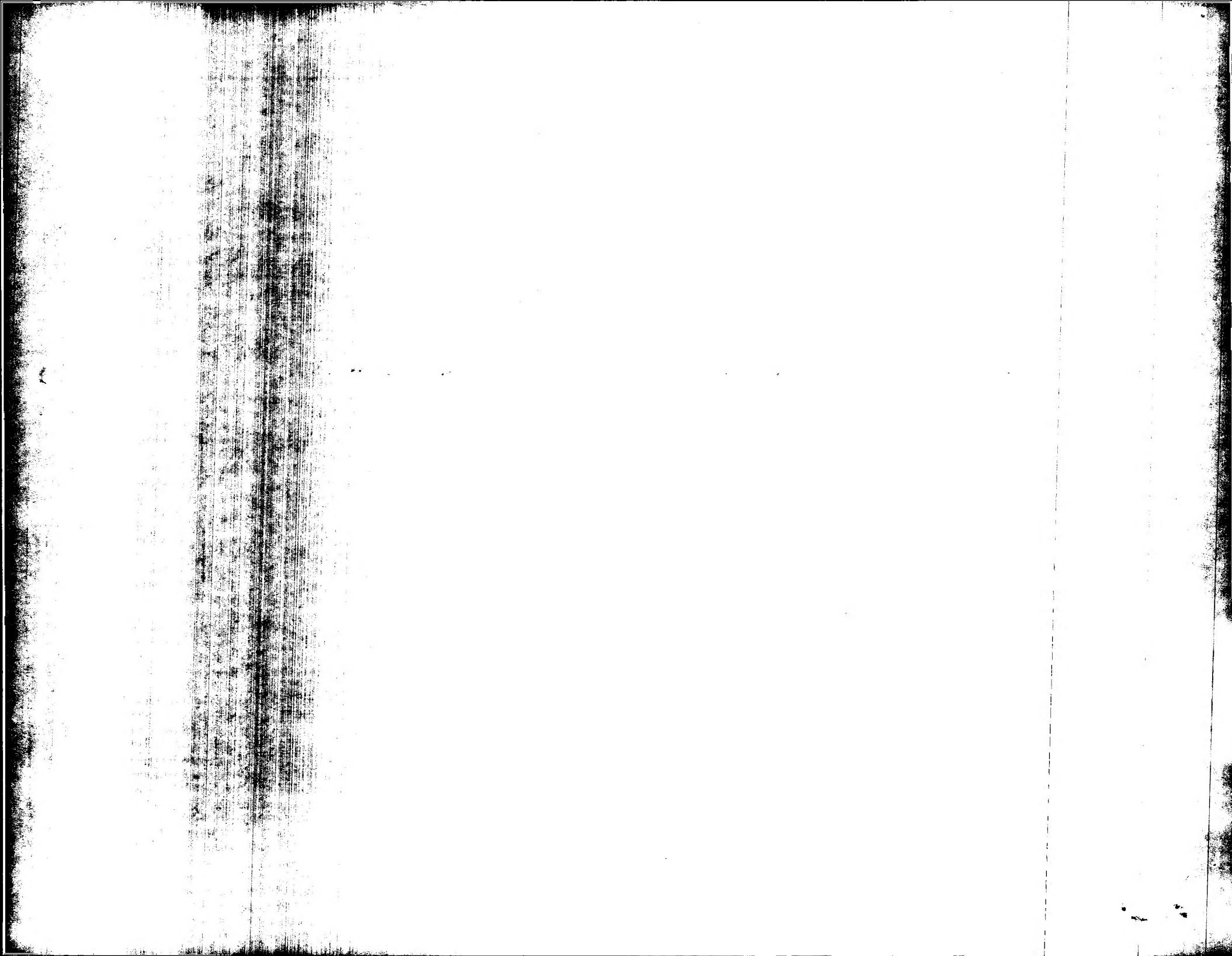
4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimension per Dwg D2622
 Check Pull test per Dwg D2622 for compliance page attached
 Check hardness with Webster tester

5 411127 4BZ





BON L CANADA INC
500 EDWARD AVENUE
RICHMOND HILL, ON L4C 4Y9

CERTIFICATE OF COMPLIANCE

Part No.	Serial No.	Lot No.	Date
11/23/07	169640	14251	1
5013	00365098	14251010	11/23/07

DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7		DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7	
1.000	DAA-897123-1	120" Mill 6061 T6	D2622
571	KGS		
547	KG	132 PC	402 M
AMS-QQ-A-200/8 & ASTM B221-00			

Mechanical Tests:

Test No.	Tensile MPA / KSI	Yield MPA / KSI	%Elongation	Conductivity	Bend/Drift	HREW
1	307.6 / 44.6	277.3 / 40.2	10.5	.0	.96	

Chemical Analysis:

SI	FE	CU	MN	MG	CR	NI	ZN	GA	V	TI	ZR	OTHER
.66	.24	.28	.07	.92	.07	.006	.06	.000	.009	.02	.000	.00

This will certify that the material described herein has been inspected and tested in accordance with Bon L Canada's standard sampling and testing procedures or in accordance with the requirements of any specifications forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

OK
08.02.11

D. VanBakel, QA Manager Signed for Bon L Canada

CERTIFIED INSPECTION REPORT

We hereby certify that the material covered by this certificate has been inspected and has been found to meet the applicable requirements described herein, including any specifications forming a part of the description and that it is representative of the material and the composition, trials and test the mechanical properties shown on the face of this document hereto.

Mark J. Young
Quality Assurance Manager
Integrals Metals
Quality Assurance Manager

Norton P. Young
Quality Assurance Manager

Alcoa Inc.

PITTSBURGH, PA DAVENPORT WORKS

Ship From: RIVERDALE, IA.

366505 66094
Ship Date Bill No. Invoice No.
2005-03-08 71201 89715
P.O. No./Govt Contract No. Customer

Page 1

412215 20041217

INTEGRIS-LAVAL

Ship To: INTEGRALS METALS LTD
3399 FRANCIS HUGHES,
LAVAL, PQ, H7L 5AS

Item Description
D152054 (N) A/T 6061-
T6 COIL SHEET FOR DISTRIBUTORS TOLERANCE
CERTIFIED BY: 54806031. PER
AMS-QQ-A-250/11, AMS4027 REV M & ASME209 REV 04 & ASME-5B-
209 REV A95 DIMENSIONAL TOLERANCES T
ASME35.2 REV 2003 ((NOT MARINE)) LIGHTLY OILED
COIL SIZES: ID 20 IN COIL WTS: MM 7500
LB PROG WGT: 8000 LB EXPORT PACK QUAN TOL +/-
30 & CQR D152054 REV 30 CUST REQ 05-03-
02 *** W/E 05-03-05 ***

Num	Package	Ticker	Lot	Weight	Quantity	UOM	PC Id/Ser#
1		264478	335683	63.62	1	PC	
2		264493	335691	64.07	1	PC	
				127.69	2		

Notes for CQR: D152054-30
PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF AMS-QQ-A-250/11 ALSO MEETS THE REQUIREMENTS OF QQ-A-250/11P. PRODUCT
PRODUCED AND MARKED TO THE REQUIREMENTS OF QQ-A-250/11P ALSO MEETS THE REQUIREMENTS OF AMS-QQ-A-250/11.

CQR: D152054-30 -Specification Limits

Temp	Dir	UTS	TYS	EL40
		ksi	ksi	pct
T6	Long Transv.	Max		
		Min	42.0	35.0

Chemical Composition	Other Other										
	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti			
Alloy 6061	Max	.8	.7	.40	.15	1.2	.35	.25	.15	.05	.15
	Min	.40	.15	.8	.04						

Lot: 335683 -Mechanical, Physical, Metallurgy, Quantometer Results

Temp	Dir	No.	UTS	TYS	EL40	
		Test	ksi	ksi	pct	
T6	Long Transv.	2	Max	50.3	45	12.1
			Min	50.2	44.9	12.1

PERSON TULL CANADA INC. P.O. - 76-06004 S.O. - 396551

Integrals Metals

8/21/2005 8:45

PAGE 003/004

FAX SERVER

D3734 Melo Little S 125 M105646
Receiving Report

Receiving Report

Supplier: John Doe

Date

Supplier: Cisco

2

الصوت voice:

Release Note Attached: Yes No
Waybill Attached: Yes No
Shipment Complete: Yes No
QC6 Inspection: On 2/17
Work Order:

Diarrhoea

Production/Admin:
Date Received/Costing
Initial

Initials of receiver (if shipment OK) Level 12 **Location**

53

4. FORMS OF PURCHASING APPROVALS

4248
5690

MONTRÉAL : 514 336-4248
FAX : 514 336-4246

DISTRIBUTEUR D'ACIER ET MÉTAUX SPÉCIALISÉS
STEEL AND SPECIALTY METALS DISTRIBUTOR

ONTARIO : 1 800 667-4248
ALBERTA : 1 800 667-4248

WIP TO:

SEP 24 2007

CE LTD
N STREET

FACTURE
INVOICE N° 179912

DATE 14/09/07

BON DE LIVRAISON N° 126264
PACKING SLIP

DATE DE LIVRAISON 14/09/07
DELIVERY DATE

TERMES / TERMS	TERR.	REMARQUES / REMARKS	PAGE N°
NET 30 JOURS	2R		001

OPTION	POIDS WEIGHT	PRIX PRICE	PAR PER *	MONTANT AMOUNT
25 48 X 96	171	550.175	CLB	940.80
	236	364.406	CLB	860.00
IGE	1	2.950	UN	2.95
POIDS TOTAL	408.00			

PRINT THE PROPERTY OF "ACIER CAMP INC." UNTIL PAYMENT IS MADE IN FULL, COMPLETE AND CASHED
EXPENSE. • ALL MATERIALS BEAR THE SAME WARRANTY AS GIVEN BY THE MANUFACTURER.
THE FOLLOWING CONDITIONS: NET 30 DAYS FROM BILLING DATE AND THE BUYER ACCEPTS TO PAY
1/2 OR 24% PER ANNUM ON ALL PAST DUE ACCOUNTS OVER 30 DAYS. • ANY DEFAULT IN RESPECT WITH THE
ACCELERATION AND PERMITS TO THE SELLER, AT HIS CHOICE TO CLAIM FOR THE BALANCE DUE OR THE
CLAIM MUST BE MADE WITHIN FIVE DAYS WITH THIS DOCUMENT ENCLOSED. • ANY MERCHANDISE
SHIPPED AND NOT PAID FOR, CANNOT BE RETURNED, MUST BE WITH OUR AUTHORIZATION AND ARRANGE
FOR RETURN.

IF CONDITION MERCANDISE RECEIVED IN GOOD CONDITION

SOUS-TOTAL	1803.75
SUB TOTAL	
T.P.S.	108.23
G.S.T.	
T.V.Q.	0.00
Q.S.T.	
TOTAL	1911.98

CERTIFIED INSPECTION REPORT

We hereby certify that the material named by the certificate has been inspected with, and has been found to meet, the applicable requirements described therein, including any specifications forming a part of the description and that it is representative of the material and the composite finds and that the mechanical properties shown on the face of this sheet are as follows:

Walt J. Winkle,
pioneer of the Great Northern Woods

Norton P. Young
Norton P. Young
Quality Assurance Manager

Alcoa Inc.

PITTSBURGH, PA. DAVENPORT WORKS
SHIP FROM: RIVERDALE, I.A.

Ship Fresh: RIVERDALE, Ia.

Page

Ship To: INTEGRIS METALS LTD
3399 FRANCIS RICHARDS,
LAVAL, PQ, H7L 5A5

ITEM DESCRIPTION: 1000' COIL 1/2" O.D. X 1/4" I.D. 152054 (M) A/T 6061-
T6, COIL SHEET FOR DISTRIBUTOR'S TOLERANCE
QUANTITY: 7/16-54808631. PER
AMG-QQ-A-250/11 A) AMS4027 REV M & ASTM269 REV 04 & ASME-SB-
209-REV-009 DIMENSIONAL TOLERANCES ?
ASME35.2 REV 2003 (NOT MARKED) LIGHTLY OILED
COIL SIZES: ID 20 IN COIL WGT: MAX 7500
LB PRG WGT: 8000 LB EXPORT PACK QUAN TOL +/-
30 % COR D152054 REV 30 CUST REQ 45-03-
02 *** NW 05-03-05 ***

Num	Package	Ticket	Lot	Weight	Quantity	UOM	Pc Id/Ser#
1		264478	335683	6352	1	PC	
2		264493	335691	6407	1	PC	
				12769	2		

NOTES FOR CUR: D152054.30
PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF AMS-QQ-A-250/11 ALSO MEETS THE REQUIREMENTS OF QQ-A-250/11P. PRODUCT
PRODUCED AND MARKED TO THE REQUIREMENTS OF QQ-A-250/11P ALSO MEETS THE REQUIREMENTS OF AMS-QQ-A-250/11.

FOR: D152054.30 - Specification Limits

Expr	Dir	UTS	TTS	ELAD
re	Long Transv.	ESI	ESI	PCT
	Max			

Chemical Composition	Min	42.0	35.0	10			Other	Other	Each	Total	Aluminum
	SI	Fe	Cu	Mn	Mo	Cr	Zn	Ti			
	Max	.8	.7	.40	.15	1.2	.35	.25	.15	.05	.15
Alloy 6061	Min	.40	.15	.8	.04						REMAIN

Lot: 335683 -Mechanical, Physical, Metallography, Quantometer Results

Temp	Dir	Test	No.	UTS	TYS	EL40
				KSI	KSI	PCT
T6	Long Transv.	2	Max	50.3	45	12.1
			Min	50.2	44.9	12.1

tegris Metale

6/21/2005 8:45

PAGE 003, 002

132